

Date: Friday, 23/05/2008 12:41:40 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|-------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 205 SKIDTUBE "I" BEAM |
| Job Number | : 39458 | | |
| Estimate Number | : 10346 | | |
| P.O. Number | : | Part Number | : D2596 |
| This Issue | : 23/05/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2596 REV D |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 39426 | Drawing Revision | : D |
| | Type : SKIDTUBES | Material | : |
| Written By | : | Due Date | : 06/06/2008 |
| Checked & Approved By | : <u>JD 08.5.23</u> | Qty: | 4 |
| Comment | Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|-------------------------|
| 1.0 | D25003100 | Ext'n - 'I' Beam Web 4" |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick;

| | | | |
|-----|-------------|-------------|--------------|
| Qty | Part Number | Description | Batch |
| 1 | D2500-3-100 | Extrusion | <u>33940</u> |

RT 08-05-27

| | | |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1
 1- Cut D2500-3-100 to length: 99.5"
 2- Use Jig DT8093 to drill pilot holes #30
 3- Open to 0.630" diameter as per Dwg D2596
 4- Deburr

SL 8-5-27

| | | |
|-----|-----------------|----------------------------|
| 3.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Acid Etch and Alodine per QSI 005 4.1

SL 8-5-27 (4)

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

BE 08-05-27 (4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 12:41:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39458

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

SL 8-5-27

(4)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/28/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-27

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

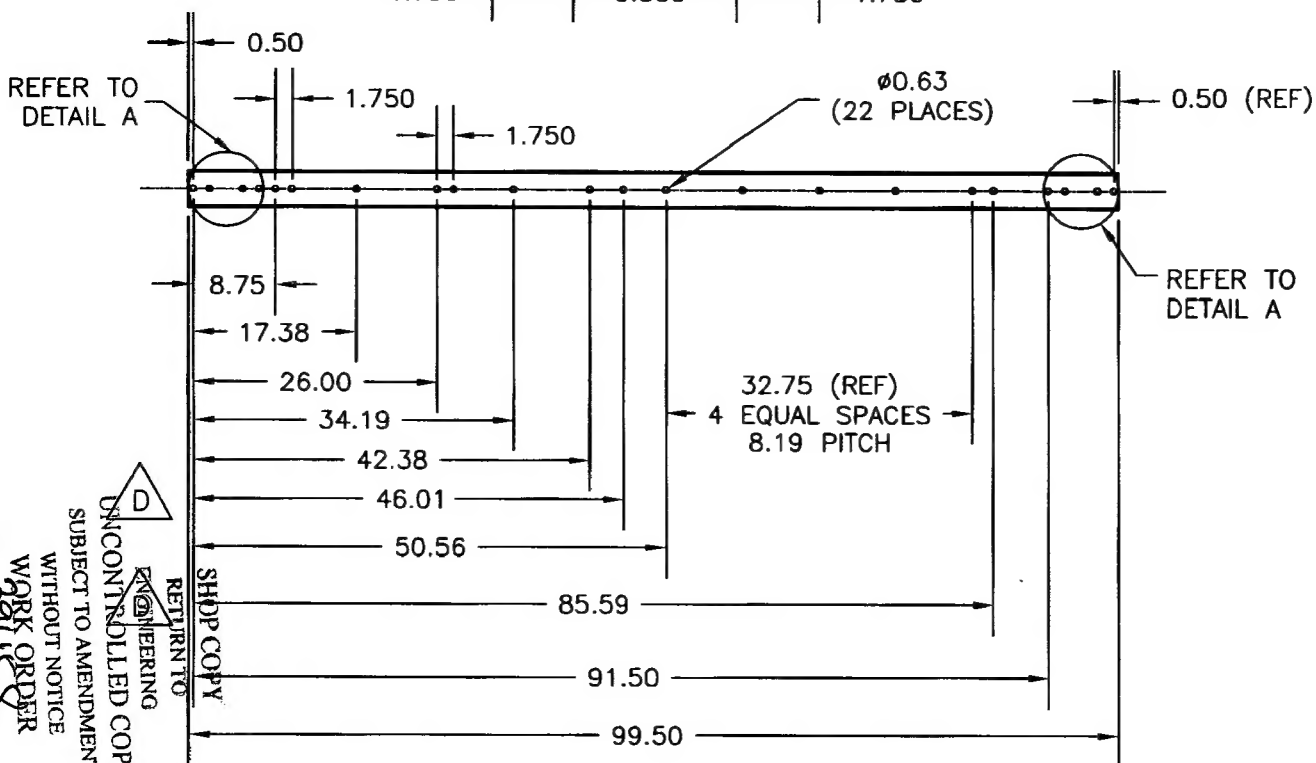
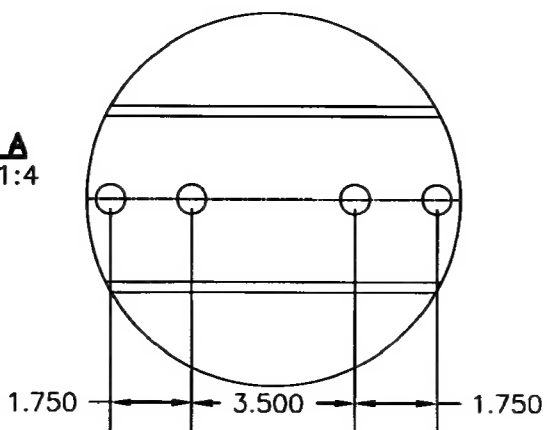
NOTE: Date & initial all entries



RELEASED
07 06 28

| | | | | |
|---------|----------|-----------------------|---------|-----------------------------|
| DESIGN | 04 | DRAWN BY | 04 | DART AEROSPACE LTD |
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 07.04.17 | DRAWING NO. | D2596 | REV. D |
| | | TITLE | 205 WEB | SHEET 1 OF 1 |
| | | SCALE | 1:20 | |
| A | 96.09.16 | NEW ISSUE | | |
| B | 97.07.23 | Ø0.63 HOLE WAS Ø0.56 | | |
| C | 98.09.14 | INCORPORATED DEO 9097 | | |
| D | 07.04.17 | INCORPORATED DEO 9183 | | |

DETAIL A
SCALE 1:4



NO. 31458
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
RETURN TO
ENGINEERING
D

D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020